Work Ord May-13-13 1:1		01651		_	*101	1651	*						Page 1
Item ID:	D3121-141				Accept	×N9	ററ	140	100	* s	etup Star	* \	S1 *
Revision ID:											Stop	7.7 1.8 1	
Item Name:	Bracket Asse	embly									Stop	*N	S2*
Start Date:	5/16/13	Start Qty: 6.00	. *	*6*		Cust	Item ID	:					
Required Date	: 5/31/13	Req'd Qty: 6.00		*6*		Custo	mer:					•0	
Reference:						in .		٠					
Approvals:	Process P	lan: MLT	Date: \[3-05-15	Tooling:		Dat	e:		R	un Star	1/7	R1*
÷ .	QC:		_ Date:		SPC (Y/N):		_ Dat	e:			Stop	*N	R2*
Sequence ID/ Work Center	ID	Operation Description			Set Up/ Run Hours	Too	I ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Re	evision Nbr							~				
D3121	, Re	v E				-			*-				
100	र्ड,				0.00			,					, DAG
100		BAND SAW	. *		•	1 i	,			4	D		08
Bandsaw		Memo			0.00	W/12/10	2	L		, –			
Jeaspa Bandsaw		Cut blanks:	(1.250" x 2.00	00") 6.600" lor	ıg , ,	, , , , , , ,		9		* <u>£</u>	Ø		
						13/0 b.a	13/0	6/01	we constitute the second	= 6			•
110				·	0.00		•	,					OASI
110	•	HAAS CNC VERTICAL	L MACHININ	G#1	***	ر م	ا ما			6	d		ာန္က 🏄
HAAS 1		Memo		Ŋ	0.00	D.A 13	106	21		YS	·		
HAAS CNC vertic	al machine #1		D3121-111 as rr3-Scribe batc		61 and Dwg D31211de	entify as D3121-	,						
	•												Ì
120		QC2- Inspect parts off n	nachine FAI/F	AIR	0.00	h a	13/06	1/21					DAS
*120		202 mopeot parts on n	i. ,		0.00	1J. F	ع د ا			6	d		l 80
QC QC	u.	Memo	1		0.00								9-89

Quality Control

												DQA:	D	ate:	
NCR:	⁄es	/ No				WORK ORDER NON-C	OI	NFORM	MANCE / UPD	ATE		OA Closed	D	ate:	
						<u> </u>		1		<u></u>		QA Closed:	U	ate:	
Work Orde	sė.					DISPOSITION				AGAINST D	E	PARTMENT	PROCESS		
	_					Rework			Skid-tube	Crosstube			Water Je	t┌	Engineering
Part N	No.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor		Quality
	_					Use-as-is		Therm	noforming	Finishing		Rec/Stor	e/Packaging	3	Other
NCR N	۱o					Work Order Update]		Large Fab	Composite			Supplie	r	
Root					Descri	ption of work order update	1	Initial	Actio	on		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descrip	otion		Date	Verification	on	QC Inspector
Doc/Data															
Equip/Tooling															
Operator															
Material					ļ										
Setup							1								
Other				İ											
Process												:			
Supplier							}								
Training							1								:
Unapproved															
			:			F _i	AUL	LT CATE	GORY						
Landi	ng G	ear				General		_		_		•		_	-
y*,		Bending			L	Bend	L	Grain				Ovalized			Pressure/Forced
. 5		Centre No	t Concer	ntric to	o/s	BOM/Route	匚	Hardwa	re			Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete	<u></u>		Part Incorred	rt .		Weld
		Crushed/0	Crimped		L	Burrs		Instruct	ions Incomplete/Ur	nclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance			Part Moved			•
		Heat Trea	t			Countersink		Mislabe	led			Positioned W	/rong		-
		Inspection	n Strip in	Tube		Cut Too Short		Misread	l			Power Loss/S	Surge		Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

150

Memo

QC

Quality Control

QC5- Inspect part completeness to step on W/O

											DQA:	Date	e: _	
NCR: Y	es/	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UPDATE		•			
											QA Closed:	Date	e:	
Work Orde	\ r .					DISPOSITION			AGAINST	DE	PARTMENT	PROCESS		
Work Orde						Rework	1		Skid-tube Crosstube	Γ	1	Water Jet	٦	Engineering
Part N	io.					Scrap	1	3	Machining Small Fab	-	Pro	d. Eng. Coor.	┪	Quality
	-					Use-as-is	1		noforming Finishing		-1	e/Packaging	7	Other
NCR N	۱o					Work Order Update]		Large Fab Composite	-		Supplier		
			ı								l a: a l		_	
Root		_	_	_		ption of work order update	1	Initial	Action		Sign &			
Cause	\perp	Date	Step	Qty		or Non-conformance	Cr	nief Eng	Description		Date	Verification	4	QC Inspector
Doc/Data	_			<u> </u>									İ	
Equip/Tooling	Ш				ĺ		ļ							
Operator	\dashv		<u> </u>				1				,			•
Material	Ц													
Setup	Ц													
Other	Ш						ļ							
Process	Ш													
Supplier		,												
Training														
Unapproved													\perp	
					···	F	AUI	LT CATE	GORY					
Landi	ng G	ear				General		_			•	-	_	
		Bending			<u> </u>	Bend		Grain		L	Ovalized	L	_	Pressure/Forced
		Centre No	ot Concei	ntric to	o/s	BOM/Route	<u> </u>	Hardwa	re	L	Over/Under	tolerance	\⊺	Temperature/Cure
		Cracks				Broken/Damaged	L	Inspecti	on Incomplete	L	Part Incorred	t L	\\	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Unclear	L	Part Lost/Mi	ssing	\	Wrong Stock Pulled
,		Cuffs				Contamination		Mainte	nance		Part Moved			
[·		Heat Trea	at			Countersink	Г	Mislabe	eled		Positioned W	/rong		

Misread

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Other

Power Loss/Surge

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ordo May-13-13 1:10		1651	· · · · · · · · · · · · · · · · · · ·	*101	1651*				Page
Item ID: Revision ID:	D3121-141 Bracket Asser	mbly.		Accept	*N900	04010	Λ* Se	etup Start Stop	14721
Item Name: Start Date: Required Date: Reference:	5/16/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	D:			IVI
Approvals:		ın:		_		nte:	Ri	un Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II	D	Operation Description Identify as per dwg & St	ock Location: 5723	Set Up/ Run Hours 55A 0.00	Tool ID	Tool # Plan Code		Reject Qty	Reject Insp. Number Stamp
160 Packaging Packaging		Memo		0.00			<u>_@X_</u>	Mihli	13-06-5
170 * 17 0*		QC21- Final Inspection	- Work Order Release	0.00			1	13/6/	11 1
QC		Memo		0.00					

Quality Control

NCR: Yes / No			WORK ORDER NON-C	CON	NFORM	MANCE / UPDATE		·			
									_	. •	
							·	QA Closed:	Da	te:	A The
Work Order:			DISPOSITION	ı		AGAIN	ST DE	PARTMENT/	PROCESS -	٠,	
Part No.			Rework Scrap			Skid-tube Crosstu Machining Small F	ab	Proc	Water Jet d. Eng. Coor.	**	Engineering
NCR No.			Use-as-is Work Order Update			noforming Finishi Large Fab Composi		Rec/Stor	e/Packaging Supplier		Other
Root		Descri	ption of work order update	П	nitial	Action		Sign &	Tay's		
Cause Date Step	Qty		or Non-conformance	Ch	ief Eng	Description		Date	Verificatio	ñ.	QG Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											
	· · · · · · · · · · · · · · · · · · ·			AUL	T CATE	GORY					•
Landing Gear Bending Centre Not Cond Cracks Crushed/Crimpe	•	s	General Bend BOM/Route Broken/Damaged Burrs			re on Incomplete ons Incomplete/Unclear		Ovalized Over/Under Part Incorrect Part Lost/Mis	t	☐ v	Pressure/Forced Temperature/Cure Veld Vrong Stock Pulled
Cuffs Heat Treat Inspection Strip			Contamination Countersink Cut Too Short		Mainte Mislabe Misread	nance led		Part Moved Positioned W Power Loss/S	rong/		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

May-13-13 1:10:51 PM

Work Order ID:

101651

Parent Item:

D3121-141

Parent Item Name:

Bracket Assembly

Start Date: 5/16/13

Required Date: 5/31/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP Rev:Pick:A04.02.18New issueKJ/DS

IPP Rev:B ECN 1060 07-11-12 DD verified by: EC

IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued%	Status
D3121-21 Bolt		Manufactured	Nọ			140	Each	71.0000	1	6	S	13/0	6/04
				Location		Loc Qty	<u>L</u>	oc Code				//	, ,
				ST235		7 í			:				
				992		41				/			
				996	01	30			(0	01	- /	′ /
D3121-241 Bearing Assembly		Manufactured	No			100	Each	77.0000	1	6	15.	3/06,	64
				Location		Loc Oty	<u>L</u>	oc Code					
				FG		14					~	مسرير	
				898		, 4					K100	1050	460
				959.	27	10					עט יעט		
,				ST235A		63							
M174B1.250X02.000		Purchased	No	986	49	63 140	f	11.7223	0.55	3.473684	2		
17-4 SS Bar 1.250 x 2.00				Location		Loc Oty	<u>L</u>	oc Code	(2 	5.0 13	3/06/0	1	··· = ·· · · · · · · · · · · · · · · ·
			•	MAT049		11.7223				•			
	•	•		114		2							
				119 123		7.7223				455 ft	•	٠	
				-> M	112408	/ × /,	155	fŧ	-	ć			
, ,	11. 4 . 4				21026			ý.	_1.	108 ft	-		
mat not	Pulled out			,	•					-			

mat not pulled out completely (this batch only)

											DQA:	Date	
NCR: Y	es /	No				WORK ORDER NON-O	100	NFORM	MANCE / UP	DATE			
i	<u>.</u>										QA Closed:	Date	·
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N NCR N	No					Rework Scrap Use-as-is Work Order Update		! Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	1	nitial	Act	tion	Sign &		
Cause] [Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
							AUL	T CATE	GORY				
Landii	Cer Cra Cru Cut He. Ins	nding ntre Nor acks ushed/C ffs at Treat spection oples in	: Strip in Bend	Tube		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/l nance led	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Rip	ples in			n —	4		Offset	Calibration		Power Loss/S	Surge	

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

Folio

ART AEROSPACE LTD escription: Bracket	Work Order:	101651
Description: Bracket	Part Number:	D3121-111
Inspection Dwg: D3121 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototy	ре
---	---------------	---------	----

Drawing	Talanana	Actual		Daire	Method of	
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
Ø0.392	+0.002/-0.000	\$ 0.3930	~		Mic	6A-03
0.75	+/-0.030	0.751	✓ ·		Vern	6A-01
0.375	+/-0.010	0.3755	~		!!	11
2.14	+/-0.030	2.150	✓	_	11	11
1.96	+/-0.030	1.962	~		11	"
0.280	+/-0.010	0.279	7		11	11
3.330	+/-0.010	3.320	~		()	11
3.630	+/-0.010	3.628	~		1)	11
R0.25	+/-0.030	RO.250	/		R-6	ref.
R0.375	+/-0.010	R 0.375	>		11	(1
Ø0.201	+0.005/-0.001	\$ 0.200	>		Vern	60-01
0.100	+/-0.010	0.100	>		1)	1)
4.580	+/-0.010	4.578	>		H6	31006
6.18	+/-0.030	6.180	\ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \ \		H-6	31006
5.89	+/-0.030	5.882	<u> </u>			N
0.080	+/-0.010	0.080	>		Vern	(A-0)
0.300	+/-0.010	0.298	✓		\$1	1)
30°	+/-0.1°	300	~		Angle M.	- CNC-03
R0.25	+/-0.030	R G.250	\ \ \		R-6.2	ref.
0.130	+/-0.010	0.128	~		Mic	GA-03
0.664	+/-0.010	0.664	~		H-6	31006
0.381	+/-0.010	0.381	<i>J</i>		Vern	69-01
0.201	+/-0.010	0.197			1,	11
0.400	+/-0.010	0.393	~		11	11
0.580	+/-0.010	0.580	/		11	(1
100°	+/-0.1°	1000	<i>-</i>		Angle M.	CNC-03
0.032	+0.000/-0.010	0.032		-	D-6	6A 08

Measured by:	D.A	DAS	Audited by:	FK	Prototype Approval:	N/A
Date:	13/06	018-80	Date:	13/06/05	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
В	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	
E	08.05.28	Tolerance revised for Ø0.201 dimension	KJ/DD X	13/



DESIGN DRAWN BY		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHEC	KED	APPROVED	DRAWING NO.	REV. E	
	#		D3121	SHEET 1 OF 10	
DATE			TITLE	SCALE	
07.11.07			BRACKET ASSEMBLY		
Α		02.04.15	NEW ISSUE		
B 03.01.16		03.01.16	ADD RIDGES; ADD MAT ADD -141/-143/-14	'L PROP; FIX P/N 4/-145/-146	
С		04.02.17	ADD CLEARANCE; USE	-241 BEARING	



			<u> </u>
D3121-21	BOLT	(1)
D3121-24	1	`	•
READING A	SCEMP	ı v	(1)

D3121-041 BRACKET ASSEMBLY

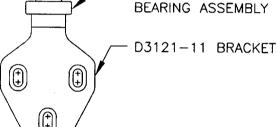
06.05.17

07.11.07

(REPLACES PREMIER P/N B30-23000-33)

D3121-25 CAP WAS 1.024, NOW 1.000

ADD TOLERANCE TO 0.032 (DETAIL B)



D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)
(2 PLACES)

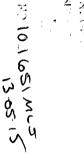
D3121-13/-14 BRACKET

D3121-21 BOLT (1) D3121-241 BEARING ASSEMBLY (1) (2 PLACES)

D3121-15/-16 BRACKET

D3121-043 (SHOWN) / D3121-044 (OPPOSITE)
BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-37/-38)



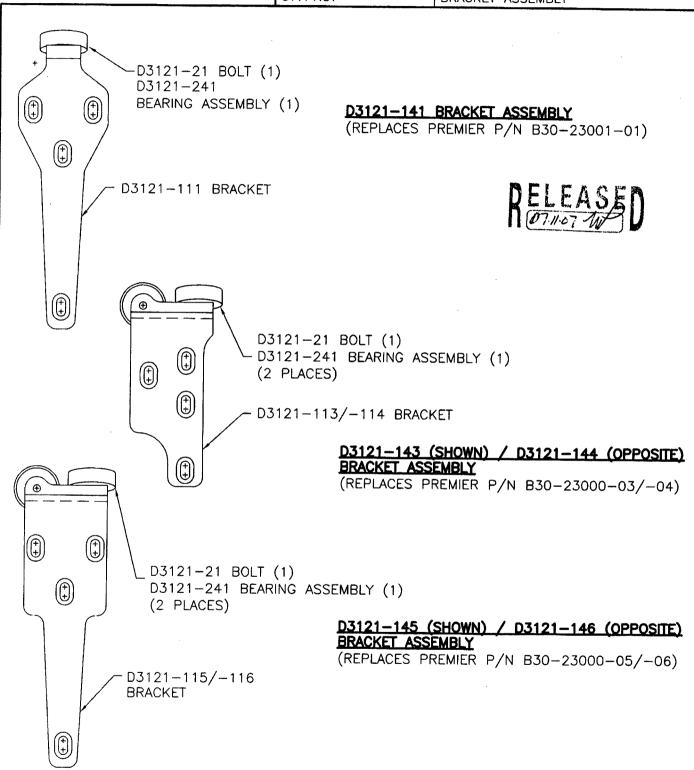
D3121-045 (SHOWN) / D3121-046 (OPPOSITE)
BRACKET ASSEMBLY

(REPLACES PREMIER P/N B30-23000-35/-36)

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DESIGN	DRAWN BY	DART AEROSP HAWKESBURY, ONTARI	
CHECKED	APPROVED	DRAWING NO.	REV. E
#		D3121	SHEET 2 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:2

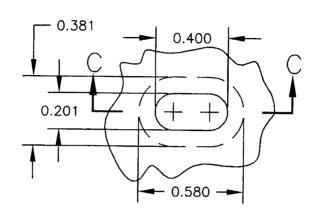


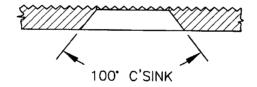
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DESIGN	DRAWN BY	DART AEROS HAWKESBURY, ONTA	
CHECKED	APPROVED	DRAWING NO.	. REV. E
1 4		D3121	SHEET 3 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:1

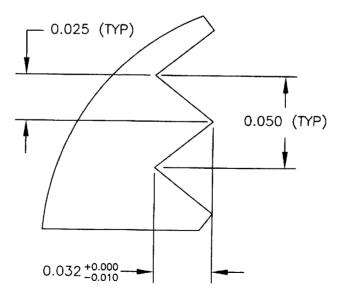
DETAIL A: SLOT DETAIL SCALE 2:1 VIEW ROTATED





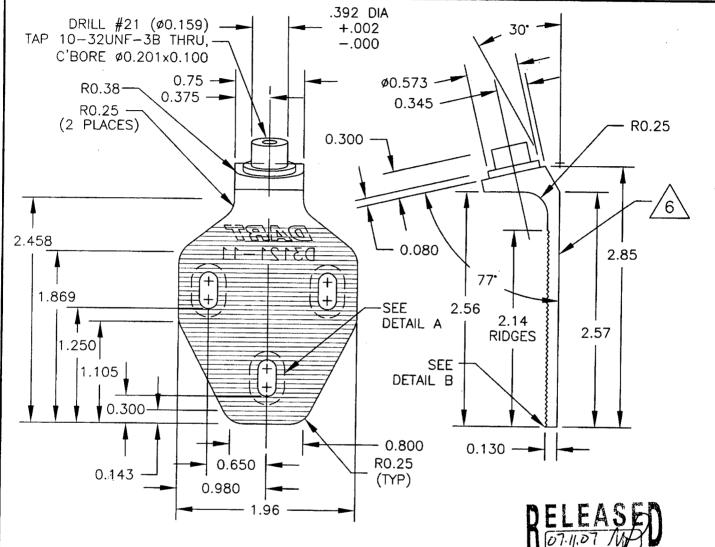
SECTION C-C

DETAIL B: RIDGE DETAIL PARTIAL SECTION SCALE 1:20





DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.	REV. E
911	-	D3121	SHEET 4 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:1

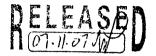


D3121-11 BRACKET

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE = 150 ksi MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005



DESIGN DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E	
9H	-	D3121	SHEET 5 OF 10	
DATE		TITLE	SCALE	
07.11.07		BRACKET ASSEMBLY	. 1:2	



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DAVBT? D3121-13

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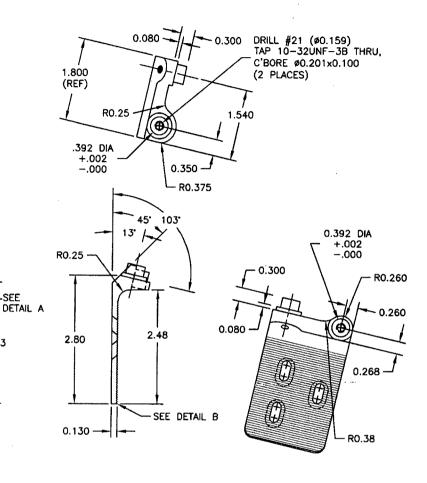
1.220 - 1.800 - 2.63

0.400

1.280 T

0.960

0.330

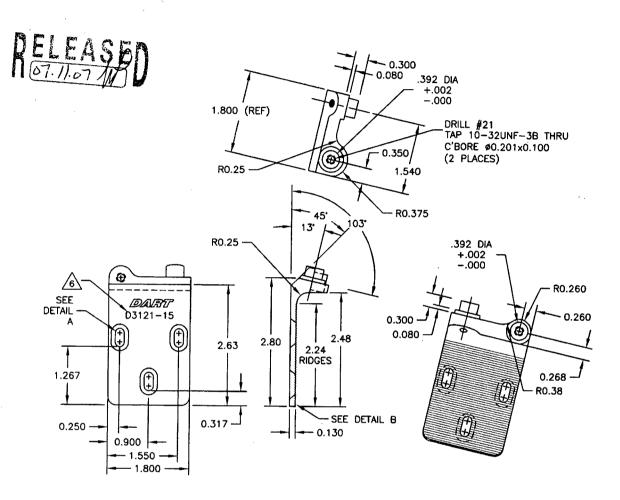


D3121-13 BRACKET (SHOWN) D3121-14 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE STRENGTH = 150 ksi MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005



DESIGN #	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E SHEET 6 OF 10	
DATE		TITLE	SCALE	
07.11.07		BRACKET ASSEMBLY	1:2	

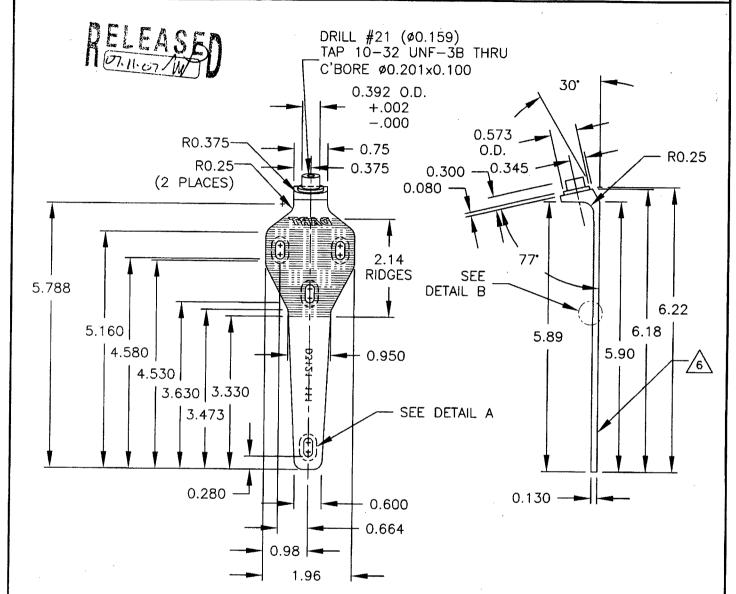


D3121-15 BRACKET (SHOWN) D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B) MIN ULTIMATE TENSILE = 150 ksi MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005



DESIGN #	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E	
9H		D3121	SHEET 7 OF 10	
DATE		TITLE	SCALE	
07.11.07		BRACKET ASSEMBLY	1:2	



D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)

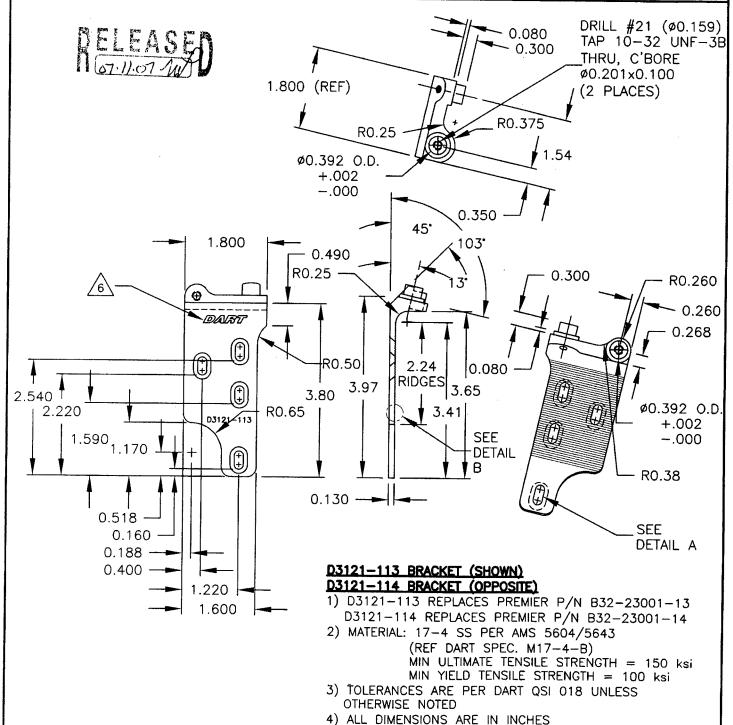
MIN ULTIMATE TENSILE = 150 ksi MIN YIELD TENSILE = 100 ksi

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHEWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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DATE		TITLE	SCALE	
07.11.07		BRACKET ASSEMBLY	1:2	



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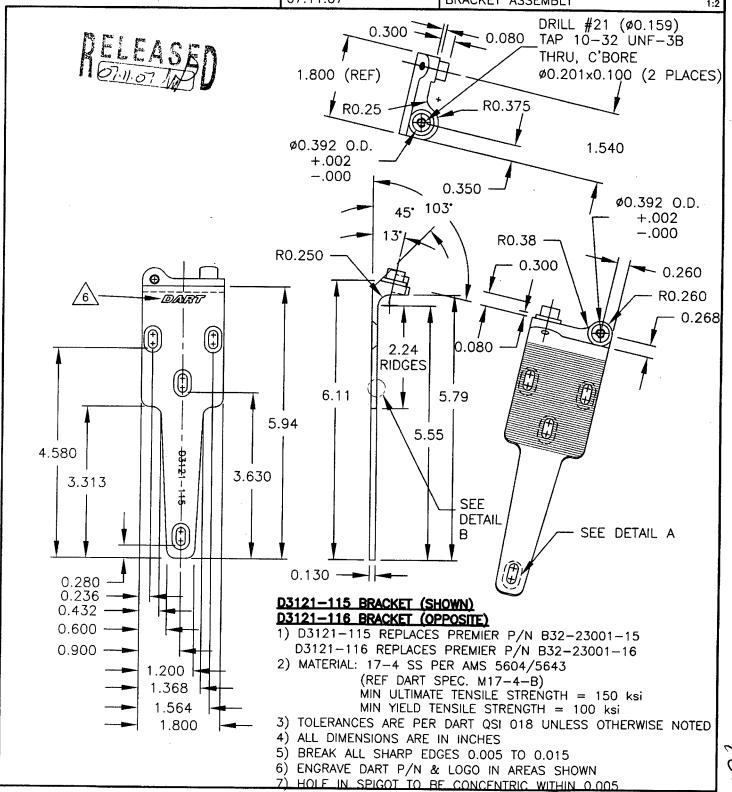
5) BREAK ALL SHARP EDGES 0.005 TO 0.015 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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10/62

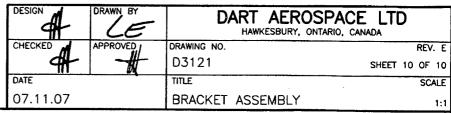


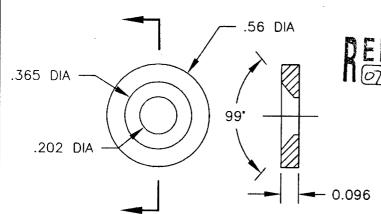
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED,	DRAWING NO.	REV. E SHEET 9 OF 10	
DATE		TITLE	SCALE	
07.11.07		BRACKET ASSEMBLY	1:2	



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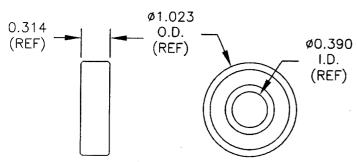






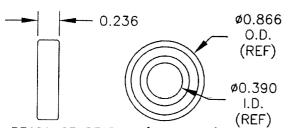
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCÈS ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



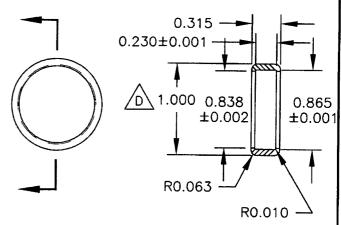
D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

0.375 TAP 10-32 UNF-3A 0.080 0.050 TO 0.060

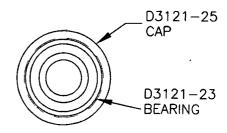
D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEBLY (SCALE 1:1)

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